

Date: Monday, 7/30/2007 1:52:34 PM  
 User: Kim Johnston

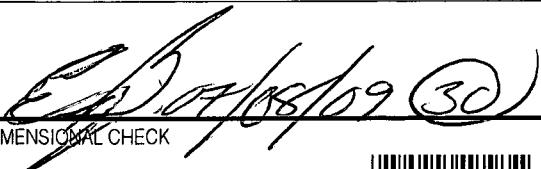
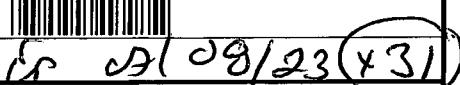
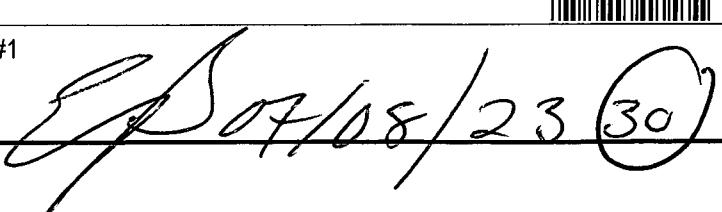
## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BEARING		
Job Number	: 33783		Part Number	: D31835		
Estimate Number	: 10091		Drawing Number	: D3183 REV. C1		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 7/30/2007 S.O. No. : N/A		Drawing Revision	: C1		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 8/15/2007 Qty: 30 Um: Each		
Previous Run	: 31796 Type : PURCHASED PARTS					
Written By	: <u>JK</u>					
Checked & Approved By	: <u>JK</u> 7/30/07					
Comment	: Est: A 03.03.27 New issue KJ/RF					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING 
Comment: PURCHASING Issue P/O: <u>4305</u> <u>CD 07/08/07</u> Bearing as per Dwg D3183 Single row, deep groove, Conrad type, shielded Possible Supplier: NSK P/N 6800ZZ Certificate of conformity note is required		
2.0	6800ZZ	Bearing 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s) BEARING		
3.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure certificate of conformity is attached 		
4.0	QC6	DIMENSIONAL CHECK 
Comment: DIMENSIONAL CHECK 		
5.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____ 		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/01/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/30/2007 1:52:34 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING

Job Number: 33783

Part Number: D31835

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



(30)

Comment: FINAL INSPECTION/W/O RELEASE

12/27/08/23

Job Completion



12/27/08/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

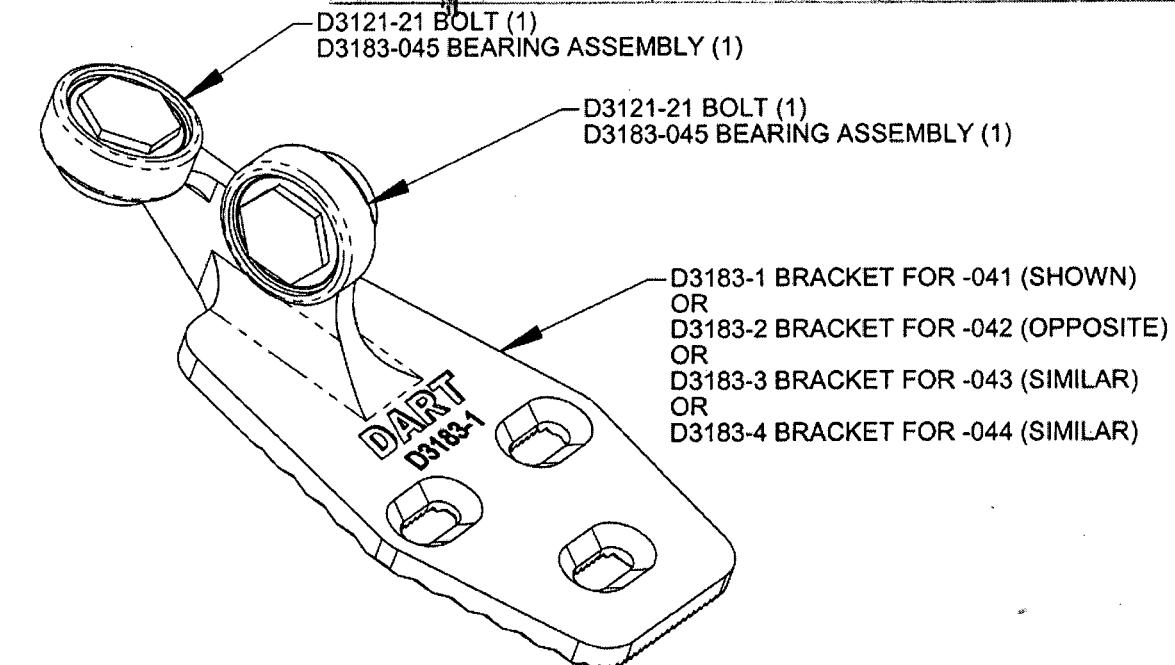
NOTE: Date & initial all entries

**DART**COPY ISSUE  
04.03.01

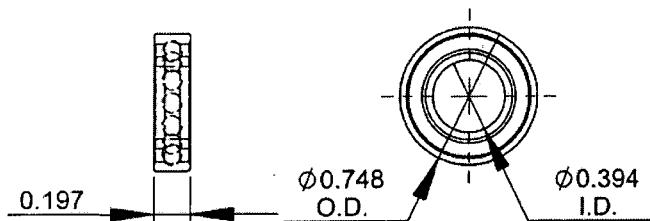
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CHECKED	APPROVED	DRAWING NO.	REV. C
		D3183	SHEET 1 OF 4

DATE 04.02.17 TITLE BRACKET ASSEMBLY SCALE 1:1

A	03.01.24	NEW ISSUE
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882
C	04.02.17	ADD -045/-9; 0.182 WAS 0.431
C1	04.11.09	0.830 WAS 0.850

**RELEASED**

**D3183-041 BRACKET ASSEMBLY (SHOWN)**  
**D3183-042 BRACKET ASSEMBLY (OPPOSITE)**  
**D3183-043 BRACKET ASSEMBLY (SIMILAR)**  
**D3183-044 BRACKET ASSEMBLY (SIMILAR)**

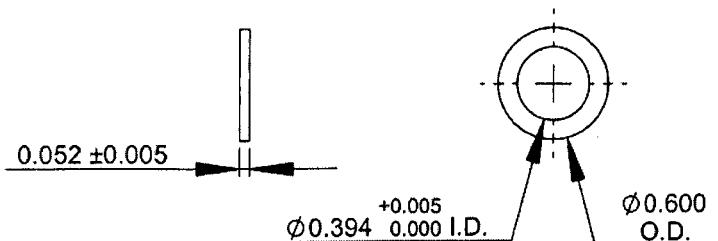


**D3183-5 BEARING:  
SPECIFICATION CONTROL DRAWING**

1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED  
 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ  
 3) ALL DIMENSIONS ARE IN INCHES

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WITHOUT NOTICE  
WORK ORDER

33783



**D3183-7 WASHER**

1) MATERIAL: AISI 303 ROUND BAR (M303R)  
 ANNEALED  
 2) BREAK ALL SHARP EDGES 0.005 TO 0.010  
 3) TOLERANCES ARE PER DART QSI 018  
 UNLESS OTHERWISE NOTED  
 4) ALL DIMENSIONS ARE IN INCHES

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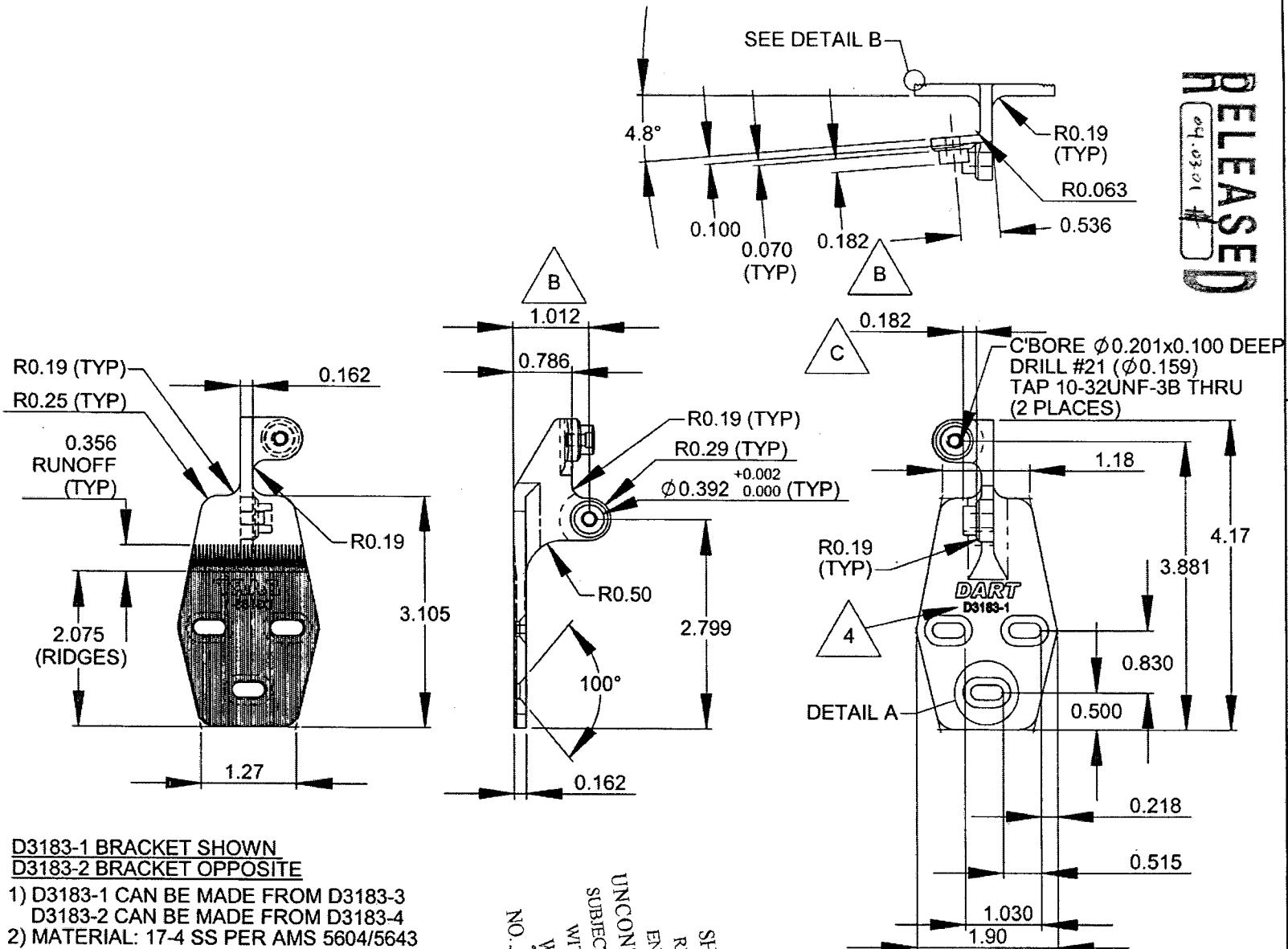
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**DART**

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DRAFT

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		SCAL
		1:2

**RELEASED**  
04.02.17

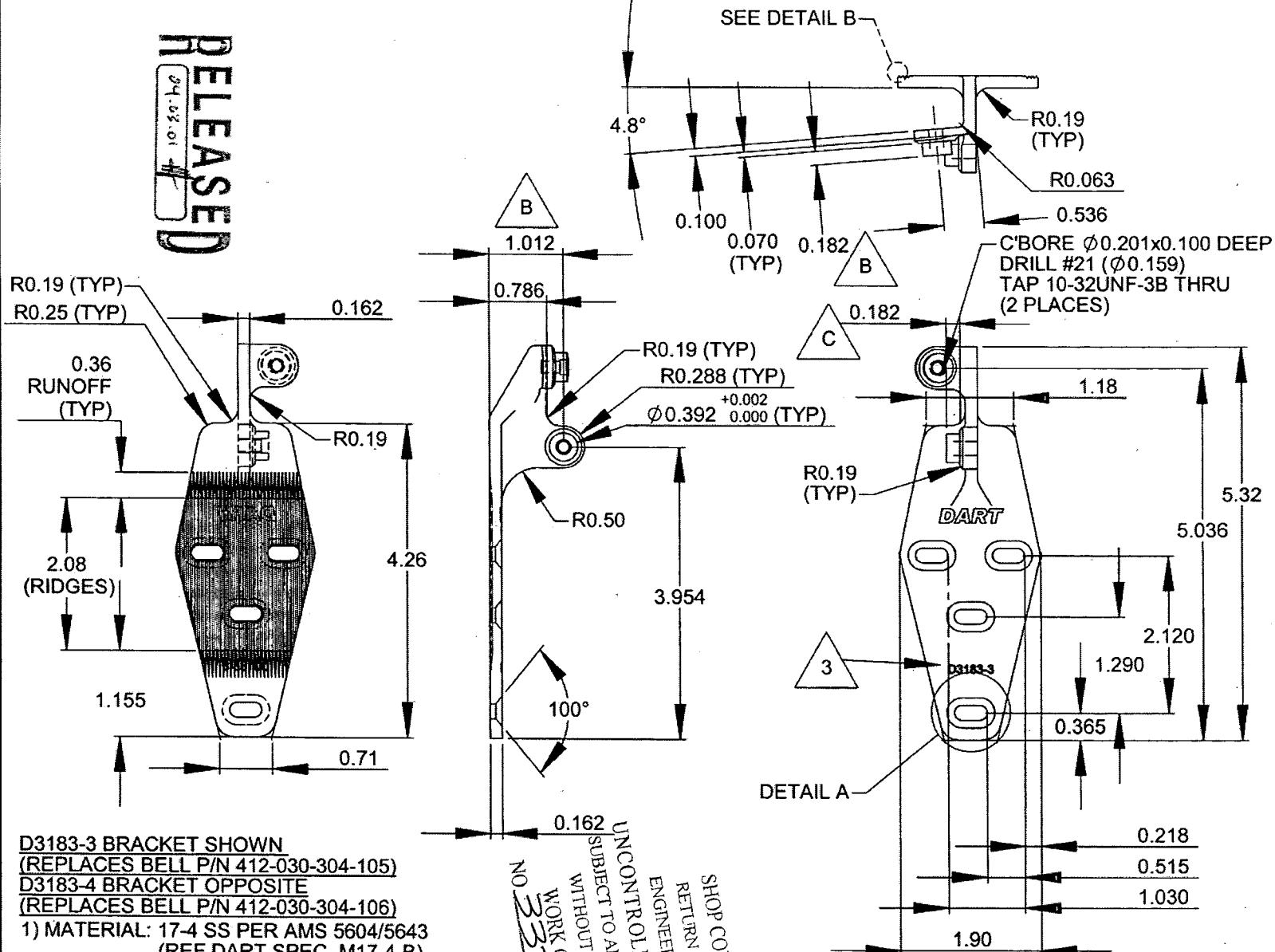


D3183-1 BRACKET SHOWN  
D3183-2 BRACKET OPPOSITE

- 1) D3183-1 CAN BE MADE FROM D3183-3  
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643  
(REF DART SPEC. M17-4-B)  
MIN ULTIMATE STRENGTH = 150 ksi  
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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NO. 33783

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JY-02.01



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D3183-3 BRACKET SHOWN  
(REPLACES BELL P/N 412-030-304-105)  
D3183-4 BRACKET OPPOSITE  
(REPLACES BELL P/N 412-030-304-106)  
1) MATERIAL: 17-4 SS PER AMS 5604/5643  
(REF DART SPEC. M17-4-B)  
MIN ULTIMATE STRENGTH = 150 ksi  
MIN YIELD STRENGTH = 100 ksi  
2) BREAK ALL SHARP EDGES 0.005 TO 0.015  
3) ENGRAVE DART P/N & LOGO AS SHOWN  
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
5) ALL DIMENSIONS ARE IN INCHES

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NO. 33783

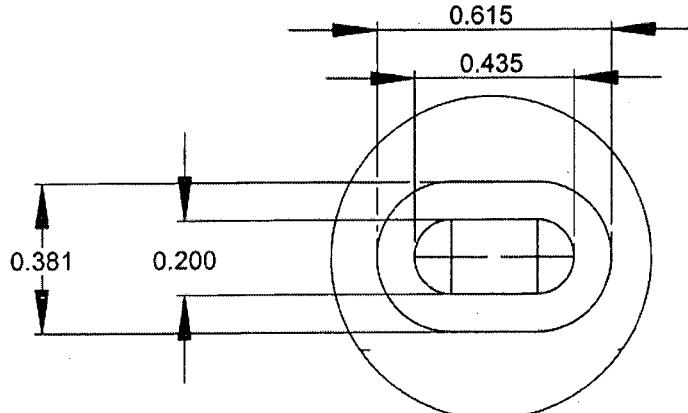
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		D3183
DATE	04.02.17	TITLE
		BRACKET ASSEMBLY
		SCALE
		1:2
		REV. C
		SHEET 3 OF 4



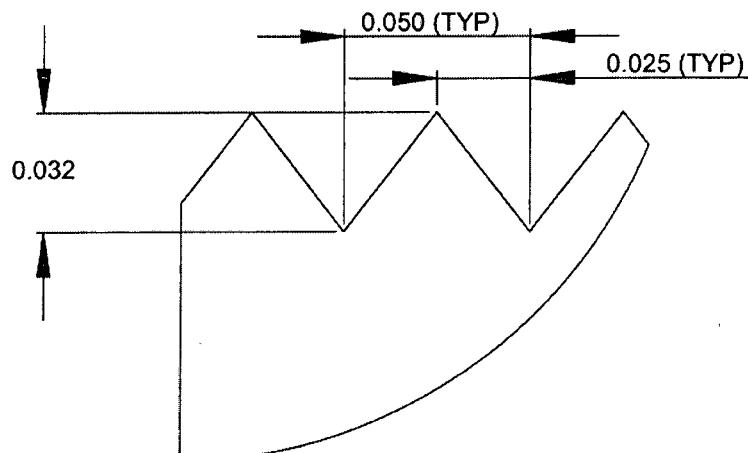
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CHECKED	APPROVED	DRAWING NO.	REV. C
		D3183	SHEET 4 OF 4

DATE 04.02.17 TITLE SCALE 1:1

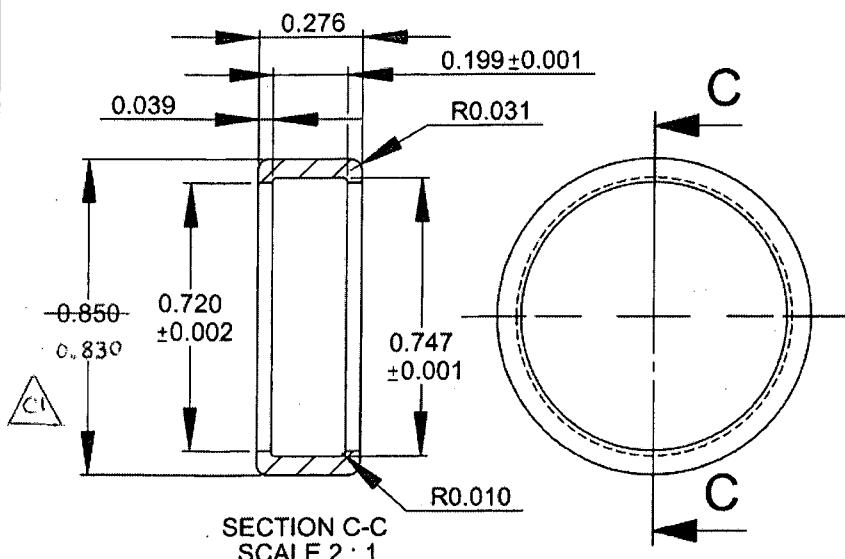


DETAIL A (2 : 1)

RELEASED  
04-03-01



DETAIL B (20 : 1)



SECTION C-C  
SCALE 2 : 1

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NO. 33783

D3183-9 CAP

- 1) MATERIAL: DELRIN ROD, Ø1.00 (REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND D3183-9 CAP

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